

Work Order ID 52662

October 5, 2009 2:53:47 PM



Page 1

Item ID: D3066-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacer

Start Date: 06/10/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: PL

Date: 09-10-5

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3066

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3066
Deburr if necessary

☐ Dwg Rev: B

☐ Prog Rev: B

☐ 2-

HB 9-11-2



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 9-11-2

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

» Soslulor



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Page 2

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Start Date: 06/10/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

gh

09/11/04

87

0

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

bk 09-11-5

87

150

Identify as per dwg & Stock Location: *seven*

0.00



Packaging

Memo

0.00

Packaging

09/11/05 (87)

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Item ID: D3066-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacer

Start Date: 06/10/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 13/10/2009 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/06
mf
09-11-05

Picklist Print

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Page 1

Work Order ID: 52662

Parent Item: D3066-1RevB

Parent Item Name: Spacer



Start Date: 06/10/2009

Required Date: 13/10/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

| Component Item ID Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M6061T6S.080 | | Purchased | No | | | 100 | sf | 302.7094 | 3.9789 | 8.6645 | | |
| <div>   </div> | | | | | | | | | | | | |
| 6061-T6 .080 Sheet | | | | | | | | | | | | |

B 944-2

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| MAT | 302.7094 | |
| 107904 | 0.02 | |
| 110254 | 2.5 | |
| 110630 | 38.0926 | |
| 112040 | 0.0437 | |
| 112141 | 33 | |
| 112512 | 37.0531 | |
| 112763 | 192 | |
| 108433 | | |
| 16254 | | |

$112812 \times 20 = 2.000$
 $112763 \times 38 = 3.7799$
 $108433 \times 18 = 1.7905$
 $16254 \times 11 = 1.6941$

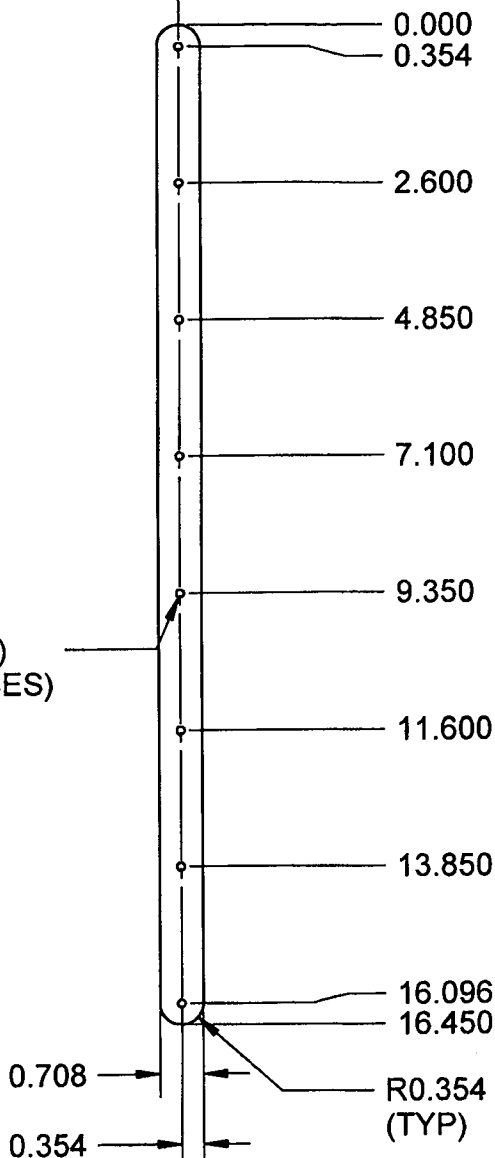


| | | | |
|-------------------------|--------------------------------|--|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CB</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3066 | REV. B SHEET 1 OF 1 |
| DATE 06.05.29 | | TITLE SPACER | SCALE 1:3 |
| A | 02.09.11 | NEW ISSUE | |
| B | 06.05.29 | ADD 6061-T6 MATERIAL | |

RELEASED

6.6.20

Ø 0.128 (#30)
(TYP 8 PLACES)



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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *52662*

BL09-10-5

D3066-1 SPACER

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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